

Work Order ID 84904

May-29-12 9:23:15 AM

84904

MIDJUNE

Page 1

Item ID: D3324-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Basket Base Assembly
 Start Date: 29/05/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 12/06/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/05/29 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3324	Rev B

100 0.00

100

Large Fab

Large Fab

Large Fab

Memo

0.00

1-Cut tubes as per Dwg D3324

Qty	Part Number	Description	Batch
3	D3324-1	Bottom Tube	<u>4119683</u>
4	D3324-3	Full Length Tube	<u>4119683</u>
2	D3324-5	Top End Tube	<u>4119683</u>
2	D3324-7	Bottom End Tube	<u>4119683</u>
10	D3324-9	Vertical Tube	<u>4119683</u>

2- Weld as per dwg

A/R 4130 rod batch: 4100075

(1x)

12-06-04

110 0.00

110

QC

Quality Control

QC9- Insp visual per QSI004- Fusion Welds

Memo

0.00

1 0 12-06-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Cust Item ID:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00		8/2/06/05					
Quality Control									
121	Pressure Wash per QSI005 4.3	0.00							
121									
HandFinish	Memo	0.00							
Hand Finishing									

Handwritten notes:
M/F
12/06/05
X/

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
130									
Powdercoat									
Powder Coating									
	Memo 1ST COAT: 2:45 START TIME: 2:45 OVEN TEMPERATURE: 400°F FINISH TIME: 3:15 ***** 2nd coat if necessary ***** 2ND COAT: 3:30 START TIME: 3:30 OVEN TEMPERATURE: 400°F Finish Time: 4:00	0.00							
140	QC3- Inspect Part Finish	0.00							
140									
QC									
Quality Control	Memo	0.00							

M121134

IX ~~✓~~ 12/06/05
IX ~~✓~~ 12/06/05
1 ~~✓~~ BR 12.6.6

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>D350-721-011</u>	0.00	84903			1	1	121266	
150									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

mw 12/06/06

12-06-06

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Picklist Print

May-29-12 9:23:19 AM

Page 1

Work Order ID: 84904

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Parent Item: D3324-041

D3324-041

Parent Item Name: Basket Base Assembly

Start Date: 29/05/2012

Required Date: 12/06/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A05.02.09New issueKJ/JLM

IPP Rev:B 08-12-16 attach DEO DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3328-3		Manufactured	No			100	Each	10.0000	2	2			
✓ *D3328-3*									**			12.05.31	
Basket Hinge													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA005				10					
				33872				10					
D3348-1		Manufactured	No			100	Each	36.0000	4	4			
✓ *D3348-1*									**			12.05.31	
Clevis													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA005				36					
				74727				36					
D3349-3		Manufactured	No			100	Each	16.0000	2	2			
✓ *D3349-3*									**			12.05.31	
Spacer Bushing													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA005				16					
				75620				16					
D3367-1		Manufactured	No			100	Each	7.0000	2	2			
✓ *D3367-1*									**			12.05.31	
Mounting Bracket													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA005				7					
				76500				7					

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Parent Item: D3324-041

Parent Item Name: Basket Base Assembly

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D3324-041

Start Date: 29/05/2012

Required Date: 12/06/2012

Start Qty: 1.00

Required Qty: 1.00

M4130NTS0.500W.035

Purchased

No

100

f

240.7376

46.6

49.05263

✓ *M4130NTS0 500W 035*

4130 Square tube .500 x .500 x .035w

**

4119683 → 51.05

12.05.31

Location

Loc Qty

Loc Code

MAT034

240.7376

109127

39.5367

109385

15.75

112786

17.6261

119441

8.8248

119506

36.34

119683

122.66

M569EX0.50-18F

Purchased

No

100

sf

86.0000

28

28

* *M569EX0 50-18F*

569 Expanded Metal

**

4112776 → 33 12.05.31

Location

Loc Qty

Loc Code

MAT018

36

120204

36

MAT019

50

112776

10

117806

4

119226

4

119404

32

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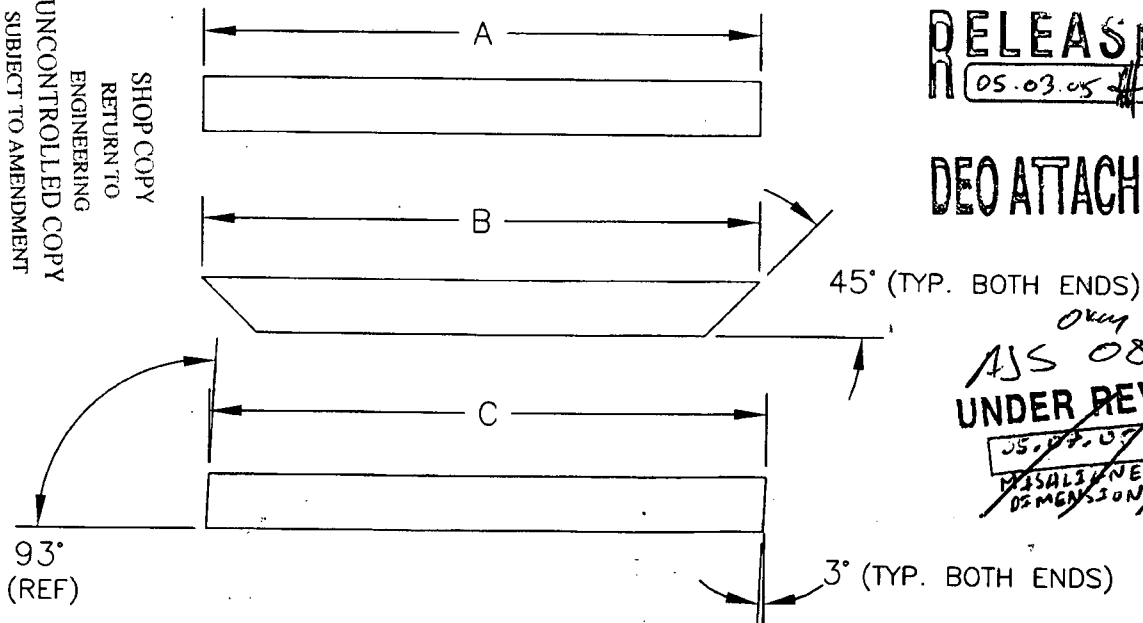
DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3324	REV. B SHEET 1 OF 3
DATE 05.03.04		TITLE BASKET BASE ASSEMBLY SCALE NTS	
A	04.10.20	NEW ISSUE	
B	05.03.04	UPDATE MESH MATERIAL SPEC	

PARTS LIST FOR D3324-041 BASKET BASE ASSEMBLY

Part No.	Quantity (-041)	Length A	Length B	Length C	Description
D3324-1	3	14.00	N/A	N/A	BOTTOM TUBE
D3324-3	4	N/A	86.50	N/A	FULL LENGTH TUBE
D3324-5	2	N/A	16.00	N/A	TOP END TUBE
D3324-7	2	N/A	15.00	N/A	BOTTOM END TUBE
D3324-9	10	N/A	N/A	11.04	VERTICAL TUBE
D3328-3	2	N/A	N/A	N/A	HINGE PLATE
D3348-1	4	N/A	N/A	N/A	CLEVIS
D3349-3	2	N/A	N/A	N/A	SPACER BUSHING
D3367-1	2	N/A	N/A	N/A	MOUNTING BRACKET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

**RELEASED**
05.03.05**DEO ATTACHED**

08.12.15
UNDER REVIEW
05.03.07 PH
MISALIGNED
DIMENSION P62

D3324-1/-3/-5/-7/-9

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: 4130 COND. N SQ. TUBE PER MIL-T-6736, 1/2" SQ. x 0.035 WALL
(REF. DART SPEC M4130N-TS0.500W.035)
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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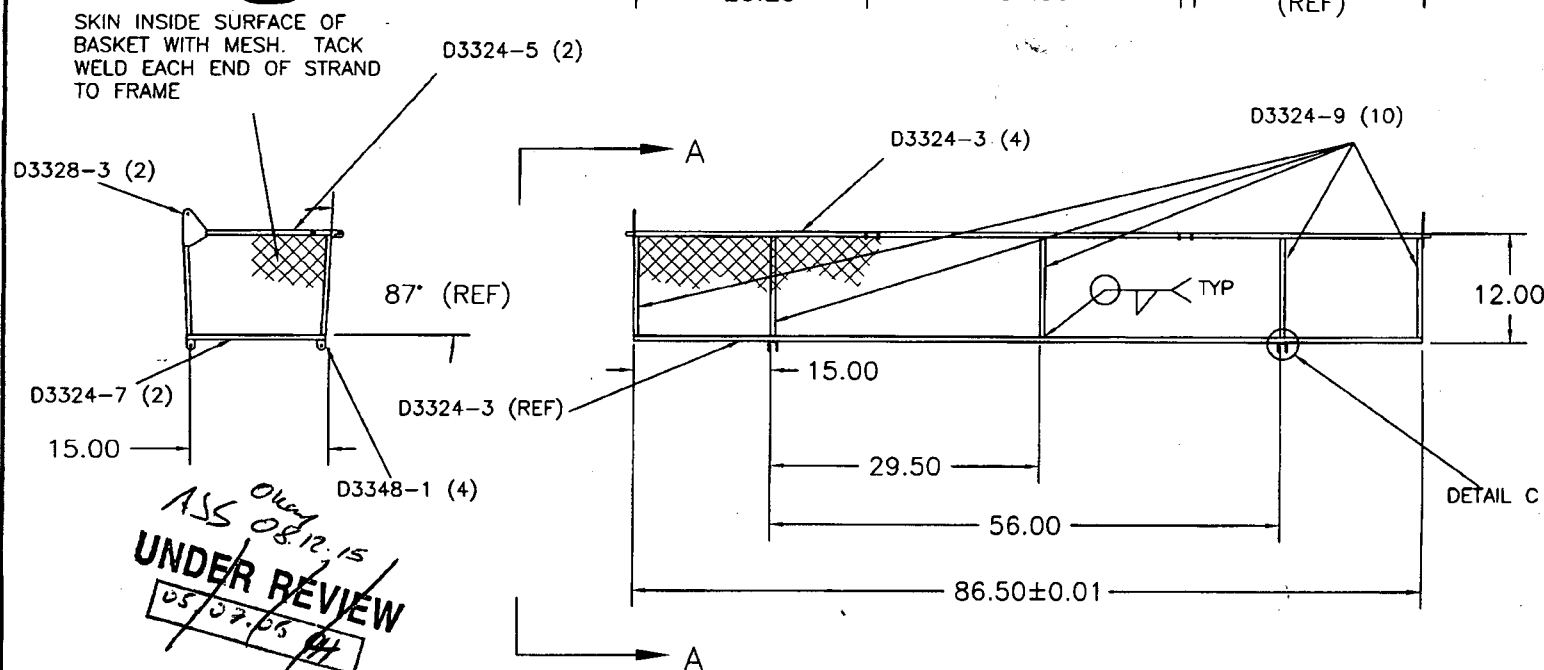
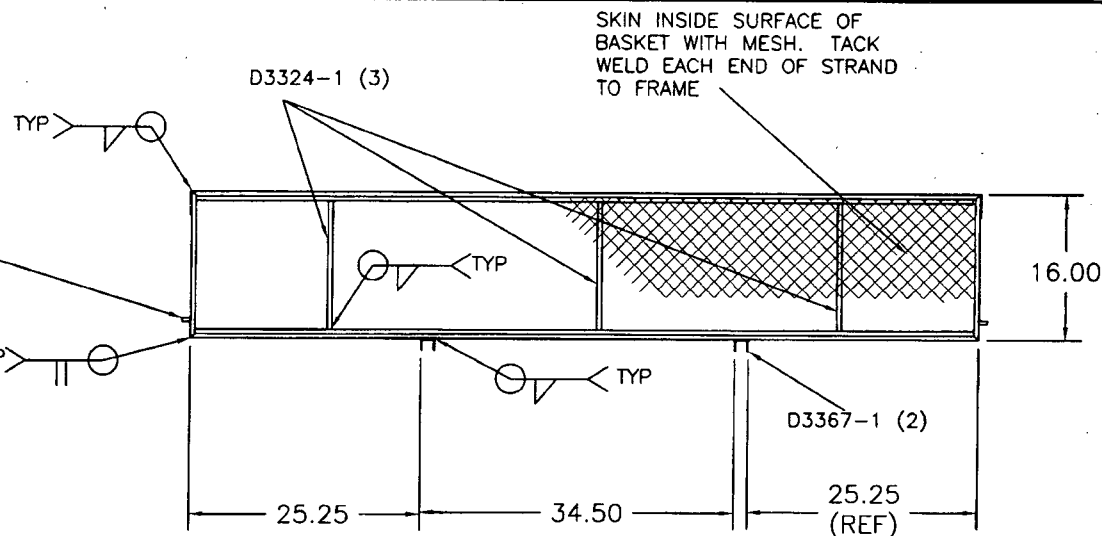
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84904

DART

DESIGN	PH	DRAWN BY	PH	DART AEROSPACE LTD
CHECKED	PH	APPROVED	PH	HAWKESBURY, ONTARIO, CANADA
DATE	05.03.04	DRAWING NO.	D3324	REV. B
		TITLE	BASKET BASE ASSEMBLY	SHEET 2 OF 3
		SCALE	1:20	



D3324-041 BASKET BASE ASSEMBLY

- 1) MESH MATERIAL: 1/2" - 18F GAUGE FLATTENED (0.040 THICK) EXPANDED CARBON STEEL (REF. DART SPEC. M569EX0.50-18F)
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 4.0 UNLESS OTHERWISE NOTED

RELEASED
05.03.05

DETACHED

ASS 08.12.15
UNDER REVIEW
05.07.05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

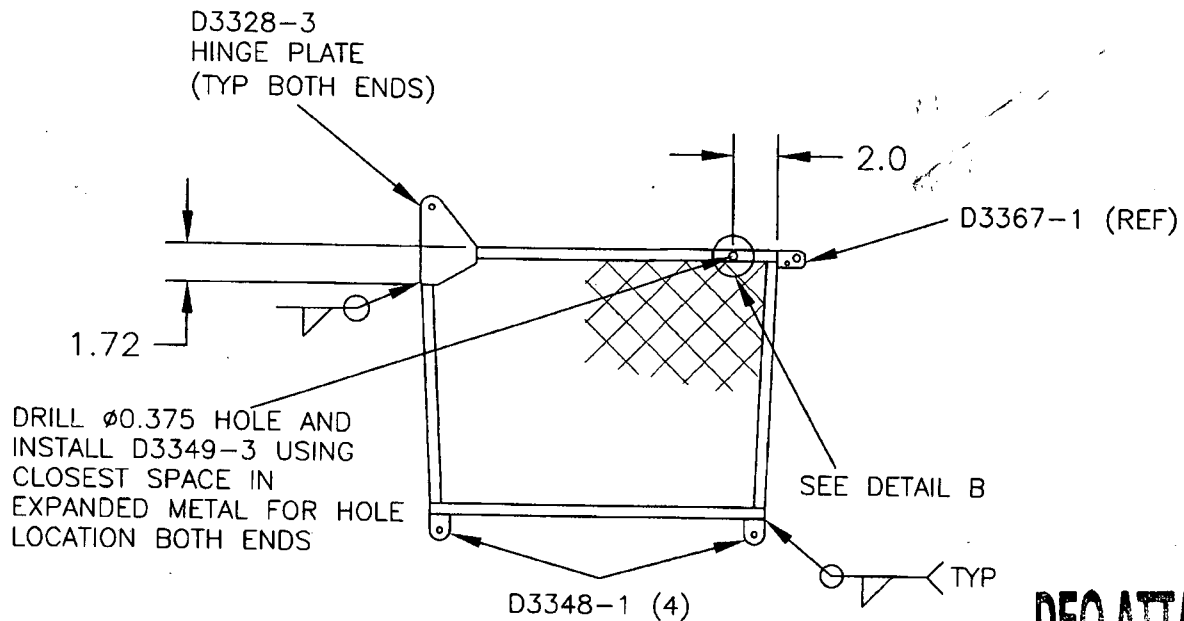
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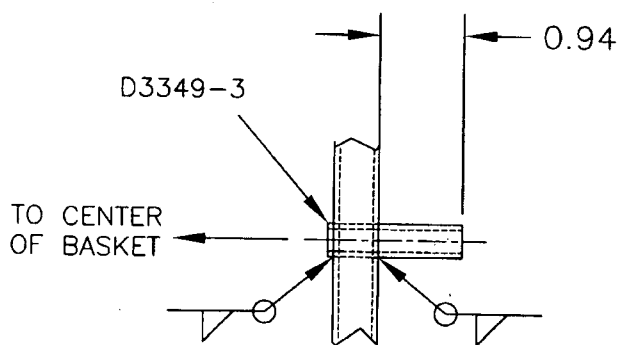
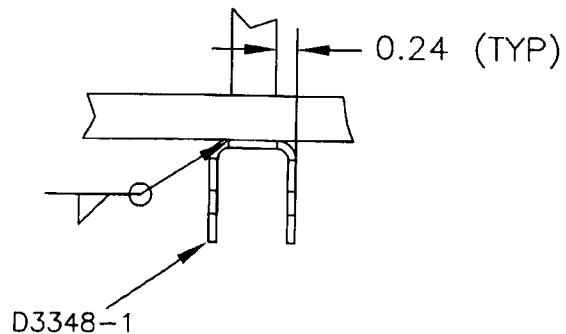
DART

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3324	REV. B SHEET 3 OF 3
DATE 05.03.04	TITLE BASKET BASE ASSEMBLY		SCALE 1:8



VIEW A-A

DEO ATTACHED

RELEASED
05.03.05DETAIL B
(SCALE 1:2)DETAIL C
(SCALE 1:2)

OK
ASS 08.12.15
UNDER REVIEW
05.03.05

84904

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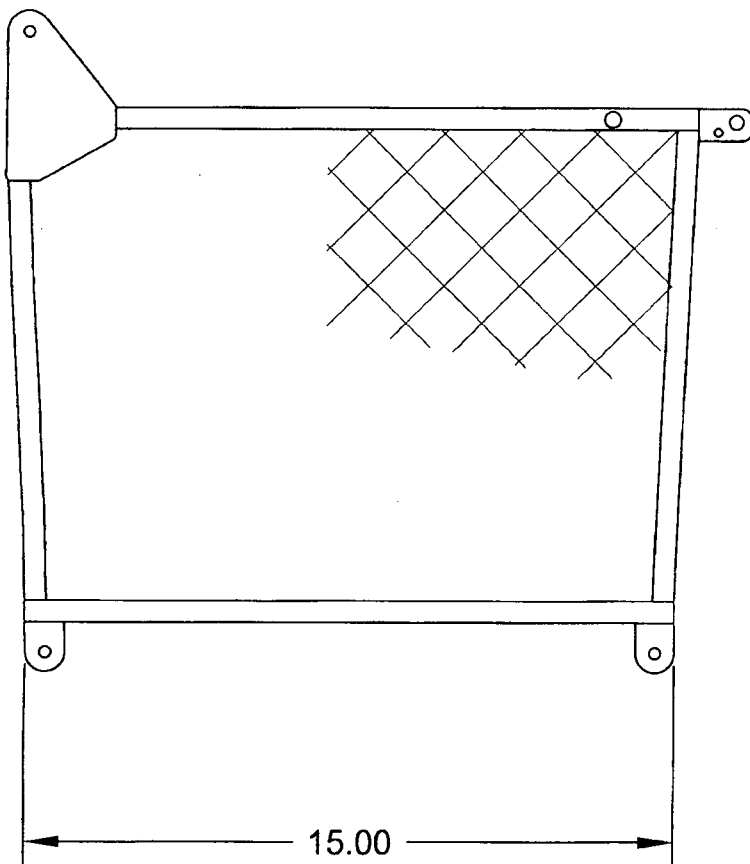
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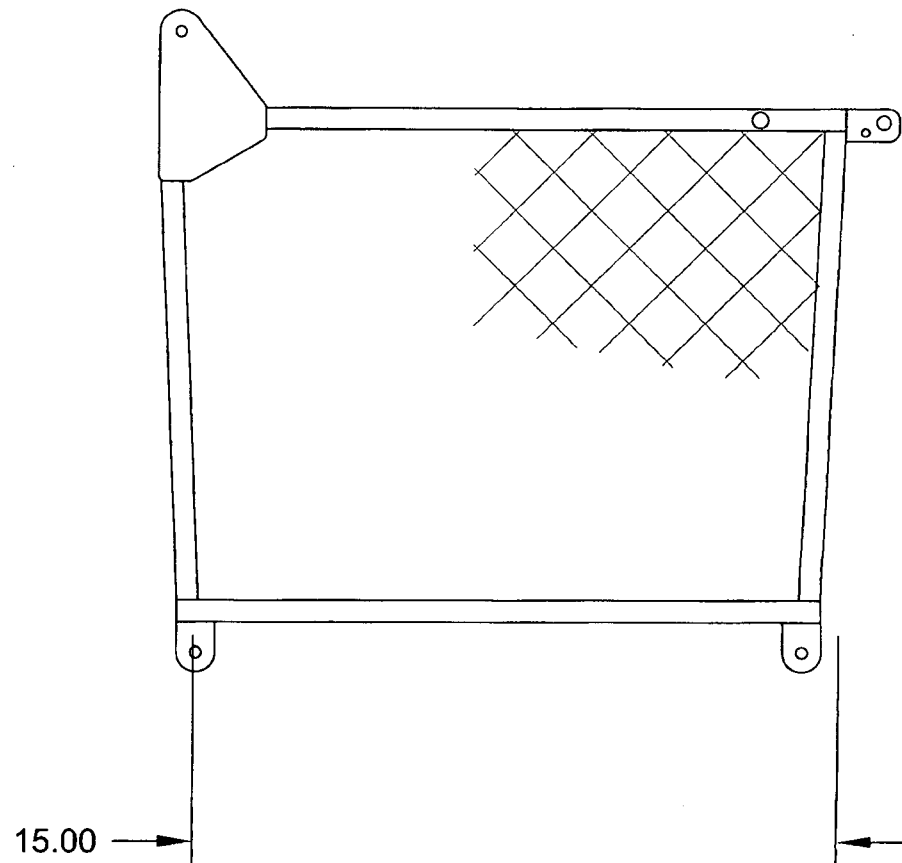
DRAWING NO. D3324	TITLE BASKET BASE ASSEMBLY	REV. B	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3324-B-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED	MFG. APPR.	APPROVED		DE APPR.		
DATE 08.11.28	DATE 08.11.28	DATE 08/12/01	DATE 08/12/01		DATE 08.12.01		

SHEET 2 MODIFY SIDE VIEW OF D3324-041 AS SHOWN:

IS:



WAS:



849 04

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